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U/R

SMD 19/04/17

D3512-1

Job Sheet 193590



Part No: D3512-1

Job Qty: 18 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/17/19

Job Tracking No:

Due Date: 4/26/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: URF DWG D3512 REV.D IPP Rev:A New Issue 06-06-20 JLM IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD IPP REV:D 13.12.11 ECN13-619/ REV.D DWG DD VERF:JLM IPP REV:D
18.03.12 DWG REV.E12 DD VERF:JFS

Ship Via:

Bill of Materials

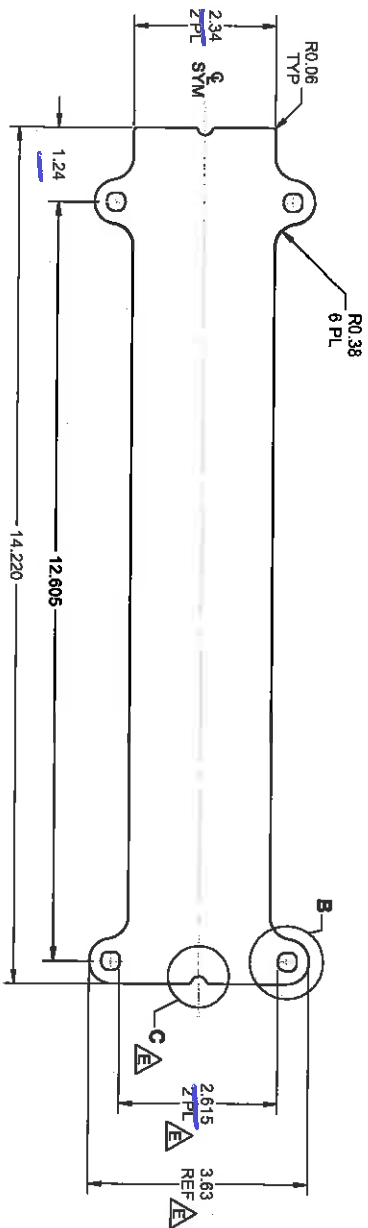
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	18	4/26/19		0.00	1.68	Waterjet - Flow		2019/04/25
	cut REV.E19 Prelim	pcs							
110	QC 2	18	4/26/19		0.00	18.00	QC 2 - 1		2019/04/25
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

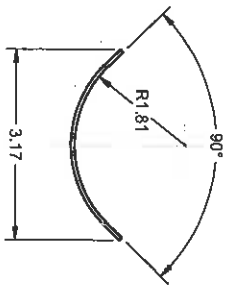
120	QC 8	18 pcs	4/26/19	0.00	0.00	QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
130	Small Fab - Brake NC - B4B	18 pcs	4/26/19	0.00	0.51	Small Fab - Brake - 1 - B4B	
						Small Fab - Brake - 2 - B4B	
						Small Fab - Brake - 3 - B4B	
140	QC 5	18 pcs	4/26/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
150	Packaging 3-1 - Stock - B4B	18 pcs	4/26/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	

					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	44-001-7 81 MAY 01 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	18	4/26/19	0.00	0.00	QC 21 - SA - 21	81 MAY 01 2019
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg Dwg Rev: <u>E19</u> Prog Rev: <u>E19</u> 2-Deburr if necessary Descriptions: 120 - QC8- Inspect parts - second check 130 - small fab - Form as per dwg 140 - QC5- Inspect part completeness to step on W/O 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M304S16GA	304/316 Sheet .063	5.2200 sf (.29 ea)	100-Waterjet - Flow - 1	S152146		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Waterjet - Flow - 1	M304S16GA	5	266	0		
Part Specifications						
Specifications could not be found.						

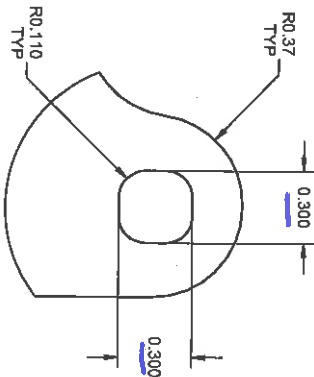
Plex 4/17/19 7:36 AM dart.lacelle.linda



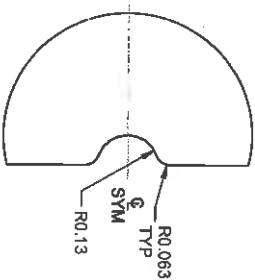
D3512-1F WEARPLATE
(FLAT PATTERN)



D3512-1 WEARPLATE
(MAKE FROM D3512-1F)



DETAIL B
SCALE 4X
4 PL



DETAIL C
SCALE 4X
2 PL

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5613 OR 5624 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.62 lbs

APPROVED BY DESIGN MANAGER

DESIGN	DW	DART AEROSPACE USA, INC.
DRAWN	SAD	HILLSBORO, OR
CHECKED	RF	
MFG. APPR	DD	
APPROVED	VS	
DE APPR		
DATE	18.03.07	
TITLE	WEARPLATE ASSY	
REV. E	SHEET 3 OF 4	SCALE
NTS		

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REFERENCE ONLY

Sho
19/04/18

Entered: _____ Date: _____

mlb
18 July 2019

NCR No. 19-7333

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: 193540		DISPOSITION		DEPARTMENT/PROCESS				Engineering	
Part No. 03512-1		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☒ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date:	Sequence #:	QTY Affected:		Disposition		Completed By		Lead hand / Supervisor	
Description Work Order Deviation				Flat pattern per 03512 Rev. D does not fit on skidtube		Mtl 03512-1 is per reference 03512 Rev. E thus attached to work order		APR 20 2019 DAS 40	
Root Cause				Acceptable minor deviation to produce intended but incomplete design		Qd/QA Coordinator DAS 68 9-89		APR 29 2019	
Operator ☒ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
Other/Details:				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					

Steven Drouin

From: Chris Provencal
Sent: Wednesday, April 17, 2019 2:13 PM
To: Steven Drouin
Subject: D3512-1/-3 wearplate deviation

Steve,

For D3512-1/-3 wearplates, it is acceptable to deviate future wearplates per the deviations of S/N 191932 / 191612

Sincerely,

Chris Provencal, P.Eng
Senior Engineer

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